

Date: Thursday, 29/05/2008 8:39:01 AM
 User: Julie Lecocq

22.344

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 39542
 Estimate Number : 11047
 P.O. Number :
 This Issue : 29/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 37337
 Part Number : D28441
 Drawing Number : D2844 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 30/05/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JUL 08.5.29
 Comment : Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TRO500W035 304 RD Tube .500 x .035W



Comment: Qty.: 1.9941 f(s)/Unit Total: 39.8811 f(s)

304 RD Tube .500 x .035W

M304TRO500W035

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using Jig

DT 8012

Batch M 107967

SB 08/05/29 (20)

2.0 BRAKE NC NC BRAKE



Comment: BAND SAW

Form per Dwg D2844 using brake and bending Jig DT 8238-B

Deburr

FF 08-06-03 (20)

SB 08/05/29 (20)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/02 (420)

4.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 11:20

OVEN TEMPERATURE: 320 400°

FINISH TIME: 11:50

BF 08-06-03

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 8:39:01 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 39542

Part Number: D28441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(20)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FS 08/06/03

6.0

QC6

DIMENSIONAL CHECK



(20)

Comment: DIMENSIONAL CHECK

ensure parts are still as per dwg D2844

0806.04

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 265

AS 08/06/05

(420)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

08/06/05

Job Completion



MF 08-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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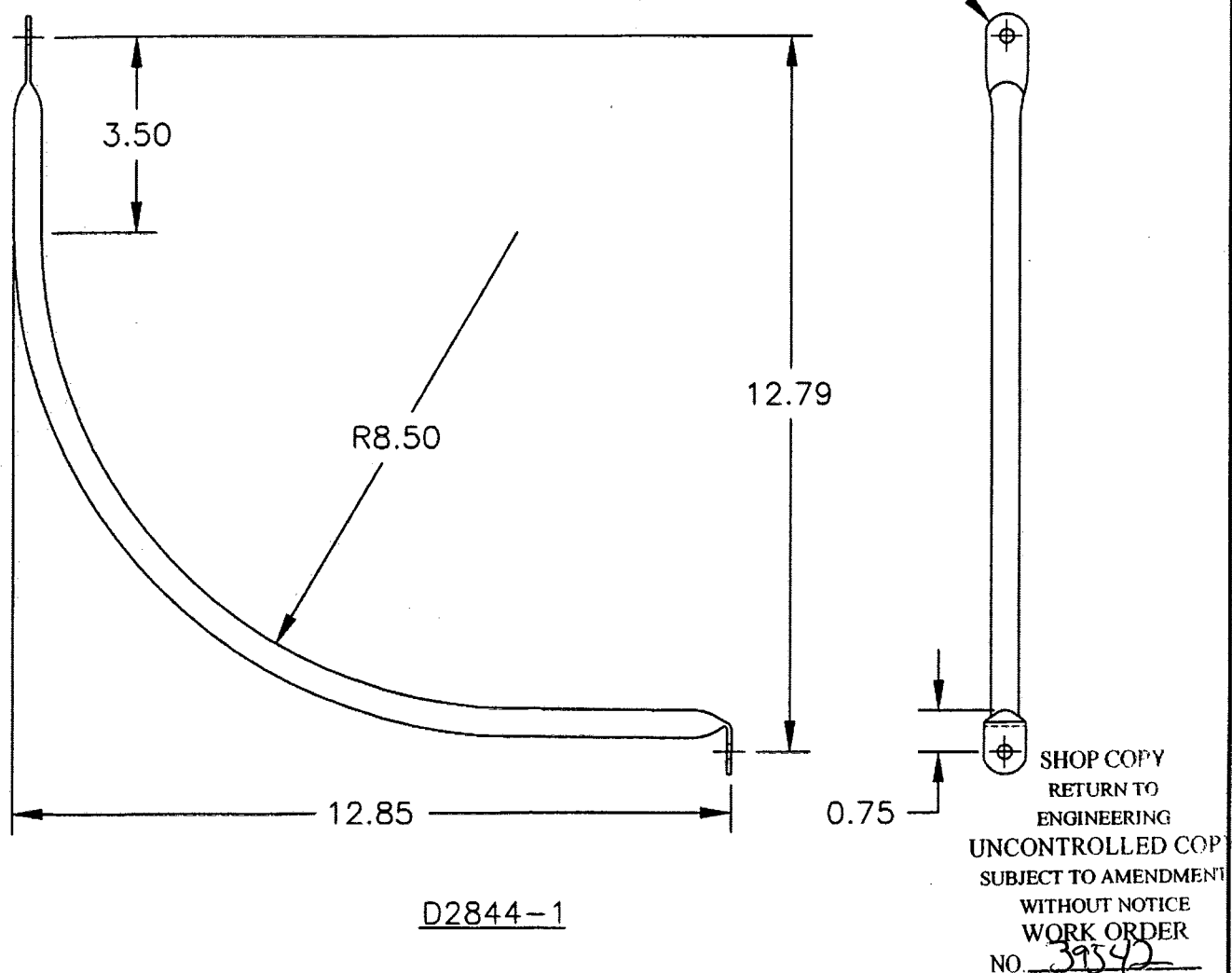
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

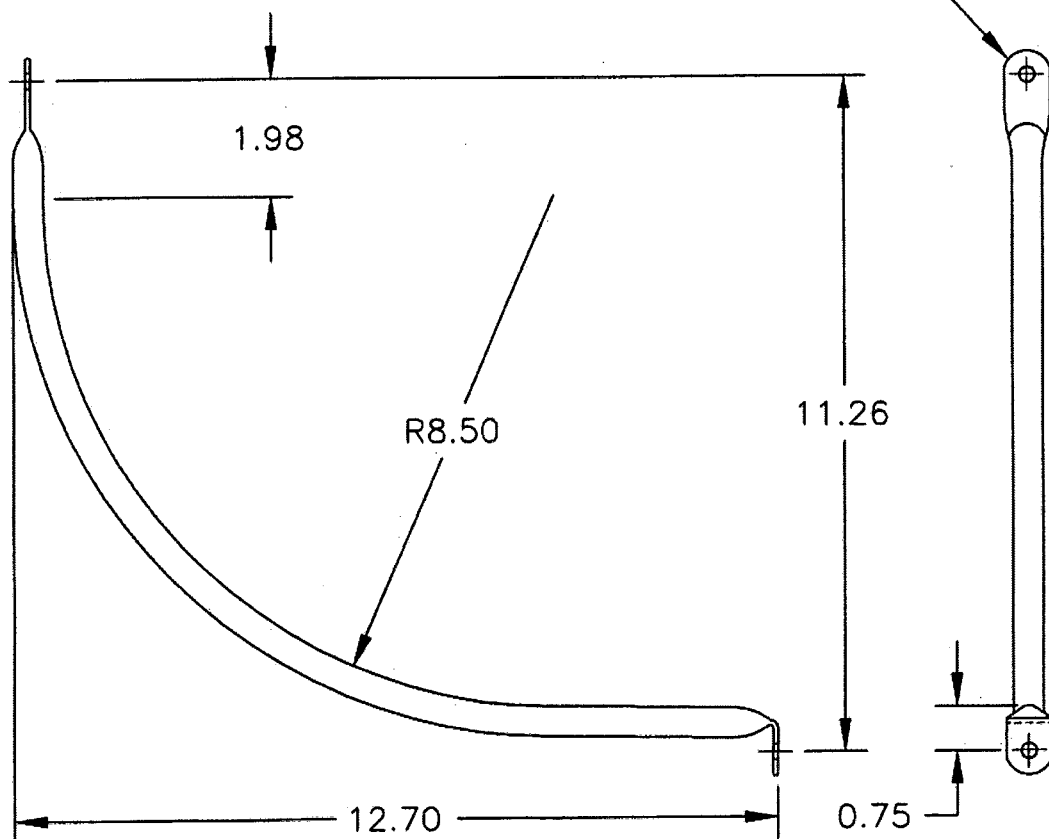
MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14	TITLE ARM		SCALE 1:3

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39592

D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3